



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D4094-1

Job Sheet 169602



Part No: D4094-1

Job Qty: 6 ea

Part Name: Bracket



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 12/14/17

Job Tracking No:

Due Date: 12/29/17

Created By: Mario Poulin

Type: SOLD

Description:

Customer: Heliservicio SA de CV (CHSER18)

Paseo De La Reforma 2654, Piso 19, Col. Lomas Altas, Delgacion Jose Miguel Hidalgo Mexico City, Distrito Federal, 11950 Mexico ph:52 (444) 101 5200

Note: DWG REV A IPP REV:A NEW ISSUE 10-04-21 JLM VERIFIED BY:DD IPP Rev:B 10.05.27 as per ECN10-548 DD verf:EC IPP Rev:C 10.06.11 added comment in seq140 DD verf:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	6 Ea	12/28/17	12/28/17	0.00	0.00	Start Up Machining-2	22	SBL 18/01/21
100	Bandsaw	6 pcs	12/28/17	12/28/17	0.00	0.13	Bandsaw1	22	SBL 18/01/21
110	CNC Vertical Machining	6 pcs	12/29/17	12/29/17	0.76	9.52	HAAS1-4	22	SBL 18/01/21
120	QC	6 pcs	12/29/17	12/29/17	0.00	0.00	QC2 Machining-2	22	SBL 18/01/21
130	QC	6 pcs	12/29/17	12/29/17	0.00	0.00	QC8 Machining-2	22	SBL 18-01-22
140	Packaging	6 pcs	12/29/17	12/29/17	0.00	0.00	Packaging3-2	ST 075	JAN 23 2018
150	QC21-SA	6 Ea	12/29/17	12/29/17	0.00	0.00	QC21		

Part Op 100 - Cut Blank 2.125" Long

Descriptions: 110 - Mill as per dwg anf Folio FA923 Deburr & Engrave as per Dwg

140 - ***IDENTIFY PART WITH ERA P/N AS PER NOTE 6 ON DWG D4094***

21
9-03 JAN 24 2018

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	M303B2.000X1.750	1	10	0	0

Part Specifications

Specifications could not be found.

Plex 12/14/17 2:05 PM dart.poulin.mario

FM 136 304 → S034030

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Water Jet ☐ Engineering ☐			
Date : _____		Step #: _____		QTY Effective _____			
Description Work Order Deviation							
Root Cause							
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cur	☐
Design	☐	Operator	☐	Bending	☐	Set-up	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/	☐
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incom	☐
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Inco	☐
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐
Past Expiry Date	☐	Manufacturing Process	☐				
Misidentified	☐	Past Due	☐	OTHER : _____			

Dart Aerospace Ltd.

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DART
AEROSPACE
S034031



Bracket

PART NO: D4094-1
Original Serial #: S034031
Revision:
Operation:
Change No:

Start up Operation 01/21/18
Job No: 169602

DART AEROSPACE LTD		Work Order:	169602
Description: Bracket		Part Number:	D4094-1
Inspection Dwg: D4094 Rev: A		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.189	+0.005/-0.001	.189	✓		P.G.	
Ø0.50	+/-0.030	.508	✓		P.G.	
0.015	+/-0.030	.015	✓		H.G.	3100G
0.940	+/-0.010	.939	✓		Vern	SBL-01
0.280	+/-0.010	.280	✓		Vern	" "
0.59	+/-0.030	.590	✓		Vern	" "
0.270	+/-0.010	.271	✓		Vern	" "
0.72	+/-0.030	.707	✓		H.G.	3100G
R0.19	+/-0.030	.190	✓		R.G.	
0.13	+/-0.030	.130	✓		mic	118-120
0.33	+/-0.030	.330	✓		Vern	SBL-01
0.60	+/-0.030	.603	✓		H.G.	3100G
R0.25	+/-0.030	.250	✓		R.G.	
Ø0.250	+0.005/-0.001	.250	✓		P.G.	
R0.25	+/-0.030	.250	✓		R.G.	
1.20	+/-0.030	1.187	✓		H.G.	3100G
1.59	+/-0.030	1.583	✓		H.G.	3100G
2.00	+/-0.030	2.005	✓		Vern	SBL-01
1.50	+/-0.030	1.501	✓		Vern	" "

Measured by: SBL/pmk	Audited by: DAE 20 9-89	Preliminary Approval:
Date: 18/01/21	Date: 18-01-22	Date:

Rev	Date	Change	Revised by	Approved
A	11.01.18	New Issue	KJ	NA